

Work Order ID 65912

Thursday, January 27, 2011 10:17:57 AM

Page 1

Item ID: D4170-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 1/27/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4170	B								

100

Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA962

ml 11.2.2

23
X

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

ml 11.2.2

23
X

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

ml 11/2/2

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65912

Thursday, January 27, 2011 10:17:58 AM

Page 2

Item ID: D4170-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 1/27/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

0.00

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

23

BB 11/02/25

130

Identify as per dwg & Stock Location: LG

0.00

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

23

BE 11/02/25

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/02/25

MF
11-02-25

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 27, 2011 10:17:55 AM

Page 1

Work Order ID: 65912

Parent Item: D4170-1

Parent Item Name: Bushing

Start Date: 1/27/2011

Required Date: 2/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD IPP
Rev:A 10.11.02 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	45.7629	0.2666	5.612632			

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT

15.68

116555

15.68

MAT014

30.0829

110968

1.416

113718

1.7

115901

26.9669

11.2.2

6.5

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

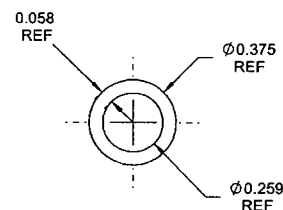
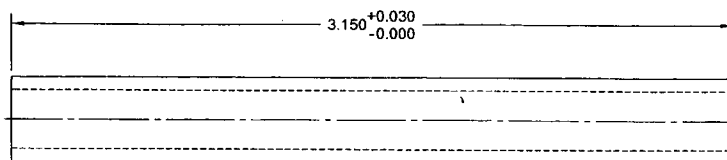
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4170-1 SPACER

W065912

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, Ø3/8 OD X 0.003 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.011lbs

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JP</i>	D4170	SHEET 1 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SPACER	NTS
DATE	10.10.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED TO THE ADDRESSEE'S EXCLUSION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

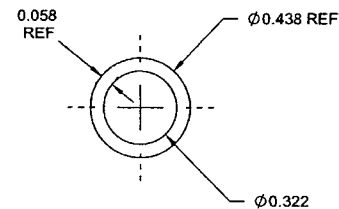
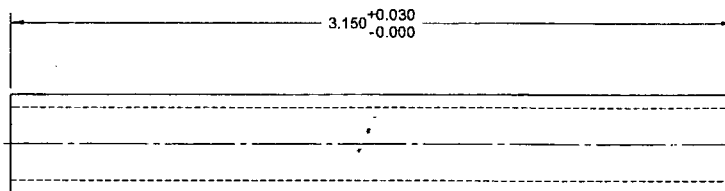
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



65912

△ D4170-3 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, Ø7/16 OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
OR
6061-T6 OR 6061-T62 TUBING, Ø7/16 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO. D4170	REV. B
MFG. APPR.	<i>JP</i>	SHEET 2 OF 2	
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SPACER	NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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